Work Order ID 74034 Tuesday, September 20, 2011 3:07:20 PM													Page	
Revision ID:	3492-13			Accept	### Market					Setup	Start Stop			
Start Date: 9/2 Required Date: 9/2 Reference:	20/2011	Start Qty: 30.00 Req'd Qty: 30.00				Cust Item I	D:							
• •	rocess Pla	n: \		Tooling: SPC (Y/N	۷):		ate:	· · • · · · · · ·		Run	Start Stop			
Sequence ID/ Work Center ID		Operation Description		Set Up Run H		Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr							<u>-</u>					
D3492	D													
Hardinge CNC Lathe Sr	nall	Hardinge CNC LATHE Memo 1-Turn as po Dwg Rev:		0.00 0.00 15 & Dwg D3492					30	/	þ			
	<i>:</i>	Folio Rev:_	Z		1230									
QC Quality Control		QC2- Inspect parts off n Memo	achine FAI/	0.00	J V 30	3		•	Ja)	9	6			
120 QC Quality Control		QC8- Inspect parts - seco	ond check	0.00	and	1/09/3	80		3.0)	مجعو			

Page 2

Tuesday, September 20, 2011 3:07:20 PM

Item ID:

D3492-13

Setup Start



Revision ID:

Plug Item Name:

Start Date: 9/20/2011

Start Qty: 30.00

Req'd Qty: 30.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Accept

Date:

Start

Stop

OC:

Required Date: 9/23/2011

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

130

Small Fab

Operation

Description

Small Fab

Memo

1-Deburr

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Run

Reject Number

Insp. Stamp

Small Fab

11/9/30

140

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

150

HandFinish Hand Finishing Chemical Conversion Coat per QSI005 4.1

0.00

0.00

30XDmfullofog

Memo

Work Order ID 74034

Page 3

Item ID:

D3492-13

Tuesday, September 20, 2011 3:07:20 PM

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Plug

Required Date: 9/23/2011

9/20/2011

Start Qty: 30.00 Req'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

Approvals:

Date:

Date:

Tooling:

Date:

Run

Start

Process Plan:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID Operation Description Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

160

Powdercoat

Powder Coating

Memo

(Flat End Only) START TIME:

OVEN TEMPERATURE

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

170

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

Identify as per dwg & Stock Location

0.00

30 Bl 11-10-6

180

Packaging

Memo

0.00

30×9 m/4/10/06

Packaging

W	ork	Ord	ler	ID	740	34
773	<i>,</i> ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	$\mathbf{v}_{\mathbf{i}}$		11/	770	-

Page 4

Item ID:

Accept

Setup Start



Revision ID:

Start Date:

Item Name: Plug

Required Date: 9/23/2011

Tuesday, September 20, 2011 3:07:20 PM

D3492-13

Start Qty: 30.00 9/20/2011

Req'd Qty: 30.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:	Process Plan:	Date:	Tooling:	 Date:	Ku
	QC:	Date:	SPC (Y/N):	 Date:	

Start

Stop

Stop

Sequence ID/ **Work Center ID** Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

Tool # Plan

Accept Code Qty

Reject Qty

Reject Insp. Number Stamp

Memo

0.00

0.00

MF 0-07

190

Quality Control

Picklist Print

Tuesday, September 20, 2011 3:07:17 PM

Work Order ID: 74034

Parent Item:

D3492-13

Parent Item Name: Plug



Start Date: 9/20/2011

Required Date: 9/23/2011

Page 1

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	32.1530	0.05	1.578947	t	V	30)

6061-T6 Round Bar .750"

<u>Location</u>	Loc Qty	Loc Code	
MAT013	32.153		
112442	0.796		
116406	0.617		
117481	12.76		1
118106	17.98		(+ PA

DART AEROSPACE LTD	Work Order:	79054
Description: Plug	Part Number:	D3492-13
Inspection Dwg: D3492 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+/-0.010	0,70			24-8	
Ø0.510	+/-0.010	0.511				
0.045	+0.000/-0.002	-044				
0.060	+/-0.005	-020				
0.060	+/-0.005	-06es				
0.500	+/-0.010	(CO)				
0.090	+0.000/-0.002	.089				
				_		
-						

Measured by:	HR	Audited by:	anh	Preliminary Approval:	
Date:	11/9/30	Date:	11/09/30	Date:	

Rev	Date	Change	Revised by	Approved	
Α	08.02.28	New Issue P/O D3492-053	KJ/DD		
В	09.05.04	Ø0.750 was Ø0.625	KJ/DD		
С	08.09.04	Tolerance revised for Ø0.750	KJ/DD		
D	10.11.05	Dimension Ø0.510 was Ø0.520	KJ i A	1	
_ E	11.06.21	Dwg Rev updated	KJ SKI	[all]	

-NAS1611 O-RING (SEE TABLE) D3492-XX PLUG (SEE TABLE)-

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	-047	Q1Y -049	-051	QTY -053	PART NUMBER	DESCRIPTION
Х							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			Х				D3492-047	PLUG ASSEMBLY
				Х			D3492-049	PLUG ASSEMBLY
					Х		D3492-051	PLUG ASSEMBLY
						Х	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			_ 1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

NOTES:
1) O-RING: POSSIBLE SUPPLIER PIN: NAS1611-XXX OR PARKER 2-XXX

No 74034

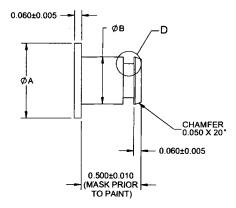
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
С	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
8	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
Α	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE

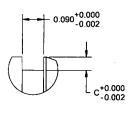
DESIGN PH		DART AEROSPACE LTD				
DRAWN	AJS	HAWKESBURY, O	NTARIO, CANADA			
CHECKED	k	DRAWING NO.	REV. D			
MFG. APPR.	JEL	D3492	SHEET 1 OF 2			
APPROVED	1 / 1/2/5	TITLE	SCALE			
DE APPR.	7	PLUG	2:1			
DATE 11.	05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL NO. IS SUPPLIED ON THE EXPRESS CONFIDENTIAL NO. TO BE USED FOR ANY REPORTS OR COMPANION TO ANY OTHER PROTECTION WITHOUT				

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- 5

-POWDER COAT THESE FACES ONLY PER NOTE 2





DETAIL D

D3492-XX PLUG

5

D3492-XX PLUG MACHINING DETAILS

P/N	A	В	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	.0.750	0.510 3	0.045	M6061T6R0.750

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061 T6R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: NIA

6) IDENTIFICATION: N/A 7) WEIGHT: N/A

DESIGN **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. D D3492 MFG. APPR. SHEET 2 OF 2 APPROVED TITLE SCALE **PLUG** DE APPR. COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE WING CONFEDENTIAL AND IS SUPPLIED ON THE COPPERSS CONCEIN NOT TO BE USED FOR MAY IMPROSE OR COPPED OR COMMANICATED TO MAY OTHER PRESS. DATE 11.05.24

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